

VERTICAL MACHINING CENTER**ABSTRACT OF THE DISCLOSURE**

5 In a vertical machining center, a spindle head is movable in
three mutually transverse axes directions relative to a workpiece and a
table is arranged below. A vertical stocker is disposed in the vicinity
of a machining area and stocks the bar workpiece in a vertical direction.
A hand portion which grips and releases the bar workpiece is provided
10 on the spindle head. The spindle head moves between the stocker and
the table so that the hand portion transfers the bar workpiece and
performs putting and removing the bar workpiece to the stocker and a
chuck of the table, respectively.